

Work Order ID 69402

Tuesday, May 10, 2011 2:55:39 PM



Page 1

Item ID: D2810-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Strut

Start Date: 5/10/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 5/16/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date: 10/5/10

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2810

Rev C

100

0.00



NC BRAKE

Brake NC

Memo

0.00

Brake NC

1-Punch 304/316 SS Seamless Tubing 0.5" O.D. x 0.035" wall to length as per
Dwg D2810 and spec control Dwg D2727 using Jig DT8012

2-Deburr

10x Ø m 11/05/19

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 11/05/12

FLU

120

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

m 115128.

Memo

0.00

Powder Coating

START TIME: 11:20
OVEN TEMPERATURE: 320°
FINISH TIME: 11:50

10 BL 11-5-25

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69402

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Item ID: D2810-5

Accept

Setup Start

Revision ID:

Stop

Item Name: Strut

Start Date: 5/10/2011 Start Qty: 10.00

Cust Item ID:

Required Date: 5/16/2011 Req'd Qty: 10.00

Customer:




Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	QC3- Inspect Part Finish	0.00							
QC Quality Control	Memo	0.00				10	0	11/05/25	
140 	Identify as per dwg & Stock Location: 265	0.00							
Packaging Packaging	Memo	0.00					11/5/25	100	SP
150 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							11/5/26

11-05-25
60

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 69402

Parent Item: D2810-5

Parent Item Name: Strut




Start Date: 5/10/2011

Required Date: 5/16/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP A 04.11.30 New issue KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.500W.035  304 RD Tube .500 x .035W		Purchased	No			100	f	311.7907	1.9175	20.18421			



m-f 11/05/19

Location

Loc Qty

Loc Code

MAT017

311.79068

115535

2.33

115990

5.29

116720

4.17068

117598 ✓

300

2018421

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

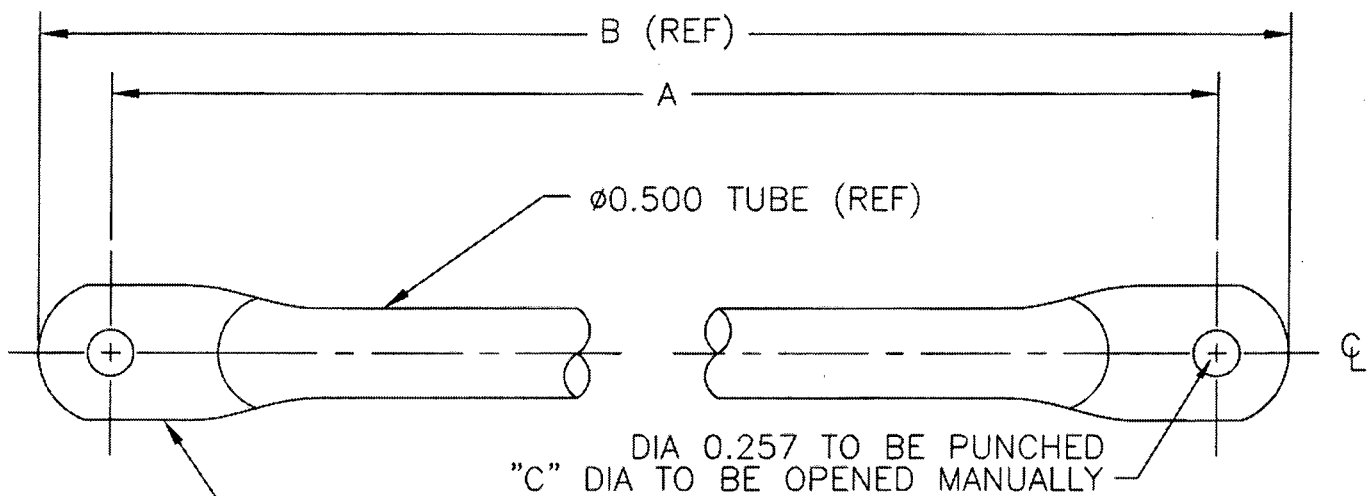
NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2810	REV. C SHEET 1 OF 1
DATE 04.11.22	TITLE STRUT		SCALE NTS
A	00.11.08	NEW ISSUE	
B	03.09.11	ADD FINISH	
C	04.11.22	ADD -5	

RELEASED

05-03-11 *[Signature]*



PUNCH ENDS PER
SPEC CONTROL
DRAWING D2727

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 69402

PART #	A	B	C
D2810-1	25.33	26.13	N/A
D2810-3	24.60	25.40	N/A
D2810-5 ✓	23.01	23.81	0.266

24.035

D2810-1/-3/-5

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE, $\phi 0.500 \times 0.035$ WALL (M304TR0.500W.035)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES

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